Tuesday, 28/11/2006 11:21:32 AM

User:

Linda Lacelle

## **Process Sheet**

Customer **Drawing Name** : 205 SKIDTUBE "I" BEAM : CU-DAR001 Dart Helicopters Services Job Number : 29723 **Estimate Number** : 10346 A14: : D2596 P.O. Number **Part Number** S.O. No. : P/A **Drawing Number** : D2596 REV C This Issue : 28/11/2006 : N/A Prsht Rev. **Project Number** First Issue Type : LANDING GEAR **Drawing Revision** NIA: : 29722 Material **Previous Run** : 05/12/2006 Qty: 12 Um: Each **Due Date** Written By Checked & Approved By : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: Ext'n -`I' Beam Web 4" D25003100 1.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Extrusion "I" Beam Web 4" m. A 06/11/24 (12 Pick: Qty Part Number Description D2500-3-100 Extrusion LANDING GEAR 1 LANDING GEAR RESOURCE 1 2.0 **Comment: LANDING GEAR RESOURCE 1** 06/11/30 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.625" diameter using a uni-bit 4- Deburr 3.0 HAND FINISHING HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 INSPECT WORK TO CURRENT STEP 4.0 QC5

Comment: INSPECT WORK TO CURRENT STEP



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STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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:					QA: N	/C Close			
	,	WORK ORD	ER NON-CONFO	DRMANCE	(NCF	<b>?</b> )			
STEP	Description of NC Section A	Initial Chief Eng	Action Descri	Section B ption	Sign 8	Section C Chief End		Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date:

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**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 29723

Part Number: D2596

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Comment: FINAL INSPECTION/W/O RELEASE

6.0



Job Completion



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## **Dart Aerospace Ltd**

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
	STEP Description of NC Section A	Description of NC	Corrective Action Section B			Verification		Approval Ap	Approval
DATE		Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Sect		Chief Eng	QC Inspector	
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NOTE: Date & initial all entries







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SHEET 1 OF 1

1:24





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98.0	97.0	96.0		7	1
98.09.14	97.07.23	96.09.16			
INCORPORATED DEO 9097	Ø0.63 HOLE WAS Ø0.56	NEW ISSUE	205 WEB	דוזרב	D2596

. •	0.50	0.63 (TYP) (20 PLACES)	0.50 (REF)
REFER TO DETAIL A -	8.750 17.375 26.000	57.313 (REF) 7 EQUAL SPACES 8.188 PITCH	REFER TO DETAIL A
· <b>&gt;</b>	34.188	91.500 ———————————————————————————————————	

1.750

DETAIL A SCALE 5:24

MANUFACTURED FROM D2500-3 EXTRUSION FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

## **Dart Aerospace Ltd**

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W/O:			WC	RK ORDER CHANG	ES				
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		Description of NC		Corrective Action Section			erification	Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	Sign & Section			
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NOTE: Date & initial all entries